

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012079**Date Inspected:** 10-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Lilin	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	Tower	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6027 (UT) report for this date. The member is identified as North Tower lift 2 & 3 Splice plate. The weld designations reviewed are as follows.
SA3-433 Quantity: 9 No.
SA3-438 Quantity: 2 No.
NDT Notification No-005205

This QA Inspector observed the following work in progress:

BAY 11:

This QA Inspector observed ZPMC qualified welding personnel identified as 040699. Perform Submerged Arc Welding (SAW) on Angle connection plate. Joint identified ND1-SA4-68-139M-8-1B, ED1-SA4-68-143M-1-1B, ND1-SA4-68-139M-7-1B, ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3221-Tc-U5-S-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

BAY 10

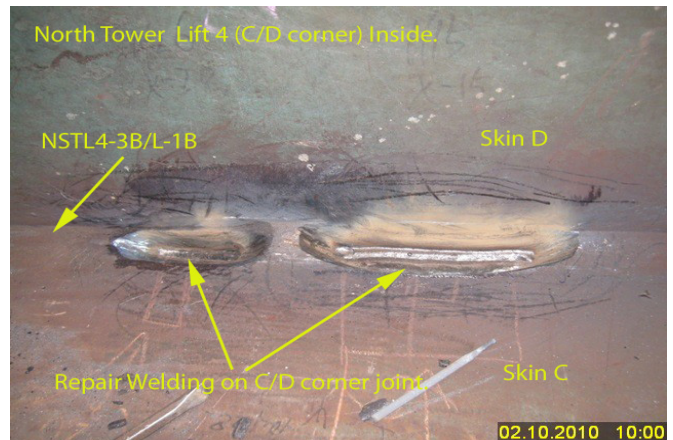
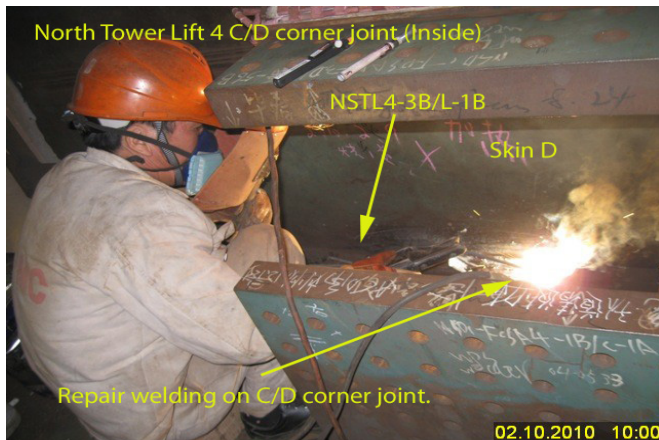
This QA Inspector observed ZPMC qualified welding personnel identified as 066236, Perform Flux Core Arc Welding (FCAW) on South tower lift 4 Fit lug. The weld identified as SSTL4-1F/L-101, near double diaphragm 123M top. ZPMC CWI Identified as Lilin, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 066236, Perform Flux Core Arc Welding (FCAW) on South tower lift 4 Fit lug. The weld identified as SSTL4-1F/L-103, near double diaphragm 123M top. ZPMC CWI Identified as Lilin, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4333-Tc-P4-F. For more information see attached photos.

Repair Welding:

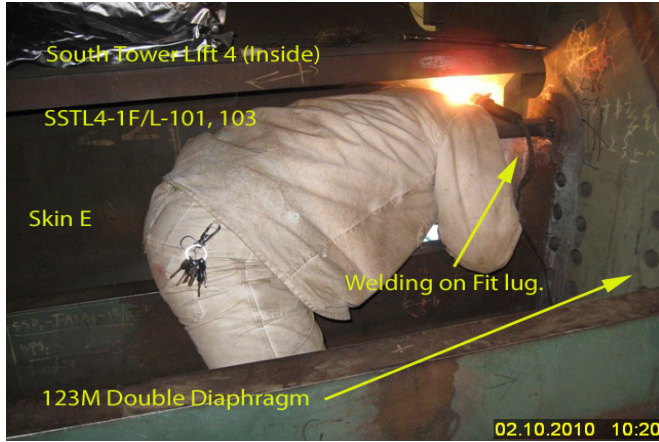
This QA Inspector observed ZPMC qualified welding personnel identified as 052930, Perform Shielded Metal Arc Welding (SMAW) on North Tower lift4 C/D corner. The weld identified as NSTL4-3B/L-1B, near 116M Diaphragm. ZPMC CWI Identified as Du Zhi Qun, with Critical welding repair report, CWR-T-CWR533, and Y location is 30600 to 30740mm. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F) - Repair. For more information see attached photos.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest phone: 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Shailesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
